



D5018-1 SUPPORT, 214 AFT

- NOTES:
- 1) MATERIAL: 17-4PH STAINLESS STEEL, H900 OR H925 CONDITION
MIN UTS = 170 KSI (38 HRc)
REF DART SPEC. D6104
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: DART LOGO AND P/N "D5018-1" IN THIS AREA WITH 0.125 HIGH X 0.010-0.020 DEEP LETTERING
PER DART QSI 044 6.3
 - 7) WEIGHT: 1.07 lbs
 - 8) INNER CONCAVE SURFACE HAS A CONSTANT RADIUS OF R1.637 (REF) CUT ALONG AN R103.6 (REF) PATH (ie. TORUS SHAPE)
 - 9) FOR ENTIRE INNER CONCAVE SURFACE: ABRADE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE WITH MEK (OR EQUIV.).
APPLY 0.03" TO 0.05" THICK LAYER OF 3M SCOTCH-WELD 2216 B/A ADHESIVE TO MATING SURFACE OF SUPPORT. ALLOW TO CURE
FOR 24 HOURS.

PRELIMINARY ISSUE

A	NEW ISSUE		CP	13.11.28
REV.	DESCRIPTION		BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	CP			
CHECKED	AP	DRAWING NO. D5018	REV. A6	
MFG. APPR.	JLM		SHEET 1 OF 3	
APPROVED		TITLE SUPPORT, 214 AFT	SCALE	
DE APPR.			NTS	
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